

[illegible]

Page 1

**Accept**

[illegible]**Setup Start**

**Stop**

[illegible][illegible]

**Customer:**

Run Start

Date:

**Tooling:**

Date:

**Stop**

Date:

**SPC (Y/N):**

Date:

### Operation Description

## Set Up/Run Hours

**Tool ID****Tool #****Plan  
Code**

**Accept  
Qty**

Reject  
Qty**Reject  
Number**

**Insp.  
Stamp**

Revision Nbr

N/A

Rev N/A

0.00

DOCUMENT CONTROL

0.00

## Memo

Photocopy blue file and type labels as per PPP D206-628-033 CHS 002

003

2  
3 8 ulouly

for BG 11-4-4

105

0.00

Eng

0.00

## Engineering

## Memo

PULL FROM HAI  
1 X D206-628-033 B50816

11/03/30

<b>DART</b> <b>Dart Aerospace Ltd.</b> 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7		TC APPROVAL # 09-09  TEL: 1-613-632-5200
P/N	D206-628-033	CHG
DESC.	Heli-Access-Step LH	STC
LOT	B50816	STC
MODEL	Bell 407	SA00500SE

MADE IN CANADA

# Work Order ID 67714

Tuesday, March 29, 2011 2:15:58 PM



Page 2

Item ID: D206-628-033

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step LH

Stop



Start Date: 3/29/2011 Start Qty: 1.00



Required Date: 3/30/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

106

0.00



HandFinish

0.00

Hand Finishing

Memo

TOUCH UP PAINT A/R  
TOUCH UP WING WALK A/R

TOUCH UP 4 X D2731-3 LUGS  
TOUCH UP 4 X D3391-041 LUGS

32 11/03/31

# Work Order ID 67714

Tuesday, March 29, 2011 2:15:58 PM

Page 3

Item ID: D206-628-033

Accept

Revision ID:

Item Name: Heli-Access-Step LH

Start Date: 3/29/2011 Start Qty: 1.00

Required Date: 3/30/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

ADD TO KIT (MISSING FROM KIT FROM HAI)

1 X D2844-1 B 62754

8 X D2732-030 B \_\_\_\_\_

3 X AN3C4A B \_\_\_\_\_

8 X AN4C14A B \_\_\_\_\_

4 X AN4C15A B \_\_\_\_\_

3 X AN960C10 B \_\_\_\_\_

24 X AN960C416L B \_\_\_\_\_

24 X NAS1515H4L B \_\_\_\_\_

12 X MS21043-4 B \_\_\_\_\_

3 X NAS1515H3 B \_\_\_\_\_

RETURN ORIGINAL PARTS

D2731-3 B47967

D3394-041 B47970

D2844-1 B50824

TO KIT

*SP*

*11/3/11*

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

0.00

*U. Valdez*

*(70)*

*D2844-1  
B50824  
D2731-3  
B47967*

Memo

*D3394-041  
B47970*

**Work Order ID 67714**

Tuesday, March 29, 2011 2:15:58 PM

Page 4

Item ID: D206-628-033

Accept

Revision ID:

Item Name: Heli-Access-Step LH

Setup Start

Stop

Start Date: 3/29/2011 Start Qty: 1.00

Required Date: 3/30/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-628-033

Location: 73PPP Rev: 3

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/4/12

11/4/12

11.04.07

# Picklist Print

Tuesday, March 29, 2011 2:15:55 PM

Page 1

Work Order ID: 67714

Parent Item: D206-628-033

Parent Item Name: Heli-Access-Step LH



Start Date: 3/29/2011

Required Date: 3/30/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM  
IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C4A  
  
BOLT

Purchased

No

Each

1,519.000

Location

ST350

116924

117094

Loc Qty

1519

508

1011

Loc Code

3 11/4/11

AN4C14A  
  
Bolt

Purchased

No

Each

30.0000

Location

ST358

115936

Loc Qty

30

30

Loc Code

3 11/4/11

AN4C15A  
  
Bolt

Purchased

No

Each

50.0000

Location

ST358

115936

Loc Qty

50

50

Loc Code

4 11/4/11

AN960C10

NAS1149C0363  
R

Purchased

No

Each

0.0000

3 11/4/11

WASHER  
AN960C416L  
  
WASHER

Purchased

No

Each

0.0000

NAS1149C0463R

24 11/4/11

# Picklist Print

Tuesday, March 29, 2011 2:15:55 PM

Page 2

Work Order ID: 67714

Parent Item: D206-628-033

Parent Item Name: Heli-Access-Step LH

Start Date: 3/29/2011

Required Date: 3/30/2011

Start Qty: 1.00

Required Qty: 1.00

D206-628-033 Manufactured No

Each 5.0000 1



Heli-Access-Step LH

Location

Loc Qty

Loc Code

FG

5

47932

5

Each

2.0000

8

D2732-030

Manufactured No



Rubber Cushion

Location

Loc Qty

Loc Code

ST410

2

65395

2

Each

12.0000

1

D2844-1

Manufactured No



Arm

Location

Loc Qty

Loc Code

ST265

12

62954

12

Each

737.0000

12

MS21043-4

Purchased No



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

697

116188

397

116549

300

Tuesday, March 29, 2011 2:15:56 PM

Shop Packet Print

Page 2

# Picklist Print

Tuesday, March 29, 2011 2:15:56 PM

Page 3

Work Order ID: 67714

Parent Item: D206-628-033

Parent Item Name: Heli-Access-Step LH



Start Date: 3/29/2011

Required Date: 3/30/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3

Purchased

No

Each

106.0000

K3

3

11/4/11



Washer

Location

Loc Qty

Loc Code

ST277

106

115935

6

116373

100

Each

53.0000

24

24

11/4/11

m114265

(13x)

NAS1515H4L

Purchased

No



WASHER

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

13

116900

13

11

Tuesday, March 29, 2011 2:15:56 PM

Shop Packet Print

Page 3

206 628 033

B50816

Touch up STEP white

wing walk

D2781-3x4 Lug Touch up white

5394-1 (K4) Lug

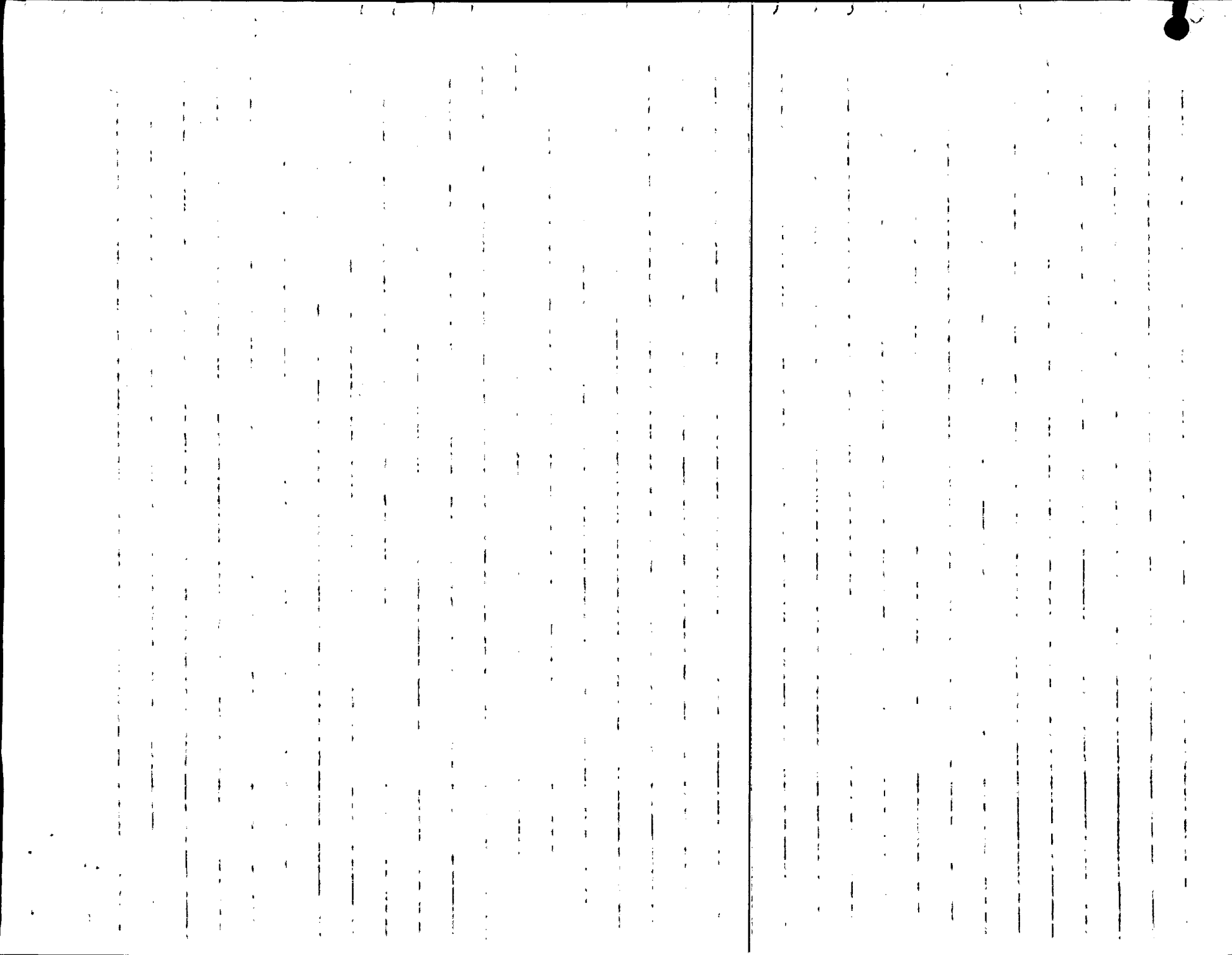
Requires Pick Kit Hardware

Requires Qty 1 D2844-1

67164

Handwritten signature and date: 12/15/00





## 5.2 D206-628-013/-014/-023/-024/-033/-034 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	AN960C10	WASHER
24	24	24	24	24	24	AN960C416L	WASHER
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

\*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

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Revision: **F**  
Date: 08.02.07

# Work Order ID 50816

July 22, 2009 3:52:47 PM



Page 1

Item ID: D206-628-033

Accept



Setup Start



Revision ID: N/A

Item Name: Heli-Access-Step LH

Stop



Start Date: 7/27/09 Start Qty: 4.00

Required Date: 7/31/09 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

*h*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp



Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

*For CL 09/08/05*

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-033 CHG 002

*Scr/08/11*

*PTD*

*Per DSZ CHG 003 9332 S*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*9/8/14 (11) SP*

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*Scr/08/11*

*24/41*

*φ*

# Picklist Print

July 22, 2009 3:52:47 PM

Page 3 / 6

Work Order ID: 50816

Parent Item: D206-628-033RevN/A

Parent Item Name: Heli-Access-Step LH

Comments:

Start Date: 7/27/09

Required Date: 7/31/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S 4 D2731-3RevB Mounting Lug	x4	Manufactured	No			120	Each	168.0000	16.0000			

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

168

37335

4

39441

12

47967

152

S  
4  
D2732RevB1

x8 @ 3600"

Manufactured

No

120

f

286.4674 8.0000

Rubber Extrusion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

286.4674

38509

24.62

43118

261.8474

S  
4  
D2844-1RevA

x2

Manufactured

No

120

Each

4.0000 8.0000

Arm

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4

46844

4

July 22, 2009 3:52:47 PM

Shop Packet Print

Page 3

# Picklist Print

July 22, 2009 3:52:47 PM

Page 4/16

Work Order ID: 50816

Parent Item: D206-628-033RevN/A

Parent Item Name: Heli-Access-Step LH

Comments:

Start Date: 7/27/09

Required Date: 7/31/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S 44 D2844-3RevA	21	Manufactured	No			120	Each	8.0000	4.0000			
Arm												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

8

46845

8

120

Each

71.0000

16.0000

46845

SD

S  
44 D3394-041RevA

24

Manufactured

No

Lug Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

71

46861

2

47970

69

47970

SD

9/8/4  
(44)

July 22, 2009 3:52:47 PM

Shop Packet Print

Page 4

## 5.2 D206-628-013/-014/-023/-024/-033/-034 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	AN960C10	WASHER
24	24	24	24	24	24	AN960C416L	WASHER
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

\*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE